

213/214

Work Order ID 51842

September 4, 2009 10:11:27 AM

Page 1

Item ID: D3848-7

Accept

Revision ID: B

Item Name: Gasket

Setup Start

Stop

Start Date: 09/04/2009 Start Qty: 4.00

Required Date: 09/11/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: UMFDate: 09-09-04 Tooling:

Date: _____

Run Start

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>								
D3848	B								

100

0.00



Waterjet

Memo

0.00

18 9-9-10

FLOW CNC Waterjet

1-Cut as per Dwg D3848

Dwg Rev: 3Prog Rev: B

2-Deburr if necessary

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

18 9-9-10

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51842

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Page 2

Item ID: D3848-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: Gasket

Start Date: 09/04/2009 Start Qty: 4.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	⇒ 8 or 10/10			(x6)	✓		
130 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				9/9/10	(6x)	SP	
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/09/11			

u 09-09-11

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Picklist Print

September 4, 2009 10:11:27 AM

Page 1

Work Order ID: 51842

Parent Item: D3848-7RevB

Parent Item Name: Gasket

Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	496.5411	12.1516	18.3374		
NEOPRENE SHEET 0.063												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

496.5410585

111469

71.1

111853

96.7589585

112508

328.6821

N/A
N/A
112508

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NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 51842
 MF
 09-09-04

D3848-1 GASKET

D3848-3 GASKET





D3848-5 GASKET

D3848-7 GASKET 

RELEASED
 09/07/04

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
 (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3848-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
 D3848-1 = 0.36 lbs
 D3848-3 = 0.44 lbs
 D3848-5 = 0.51 lbs
 D3848-7 = 0.36 lbs

B	RE-DESIGN Ø0.400 WAS SLOT HOLE ON D3848-1/3/5 (ZN C4-2, A4-2, A8-2, C4-3, A7-3); ADD D3848-7 (ZN B2-1 & A4-3); 66.87 WAS 67.36 (ZN B4-2)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3848	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GASKET	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

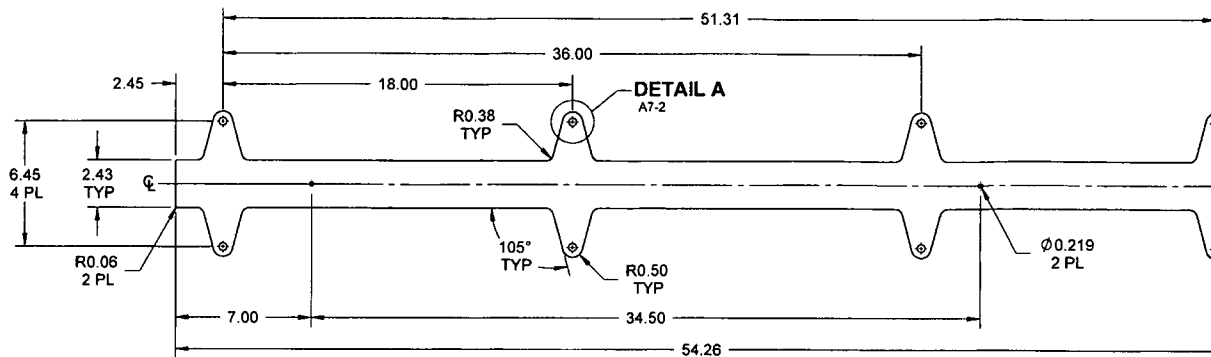
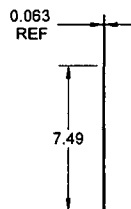
C

B

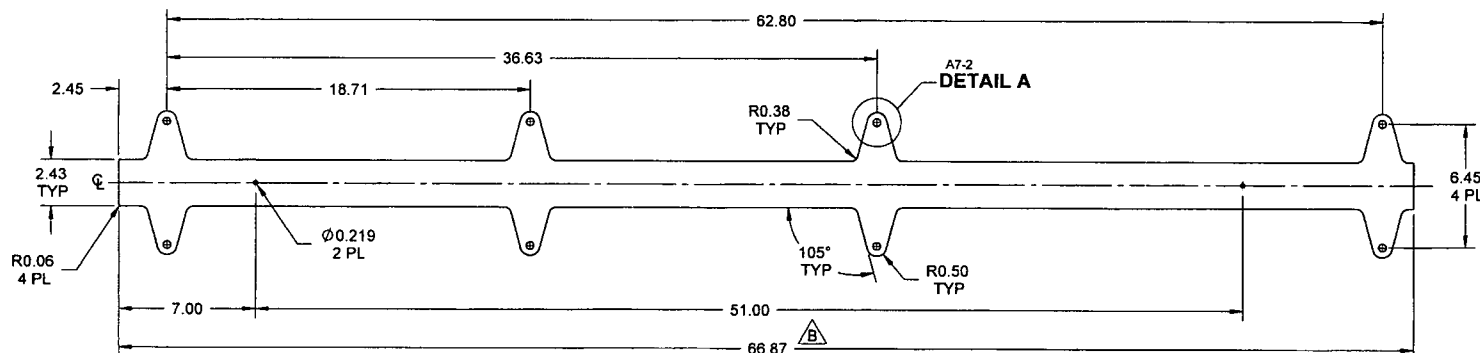
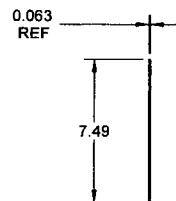
B

A

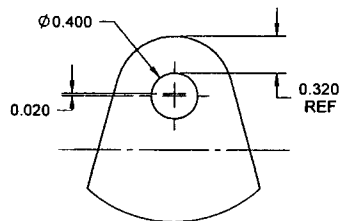
A



D3848-1 GASKET



D3848-3 GASKET



DETAIL A: SLOT DETAIL
TYP

D4-2
C3-2
D2-3
B3-3

51842

RELEASED
87/67/15/11

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO. D3848	REV. B
MFG. APPR.	RF	SHEET 2 OF 3	
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8 7 6 5 4 3 2 1

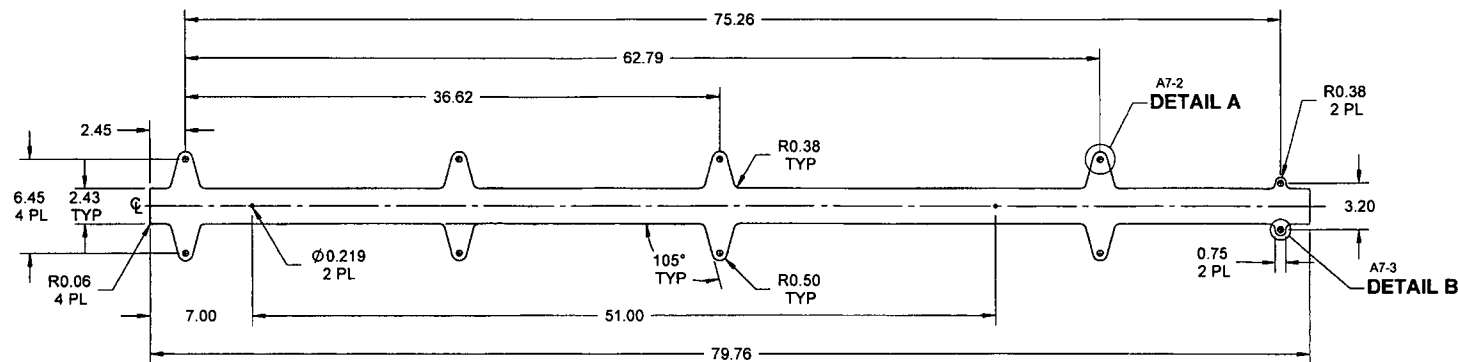
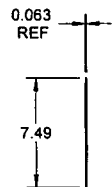
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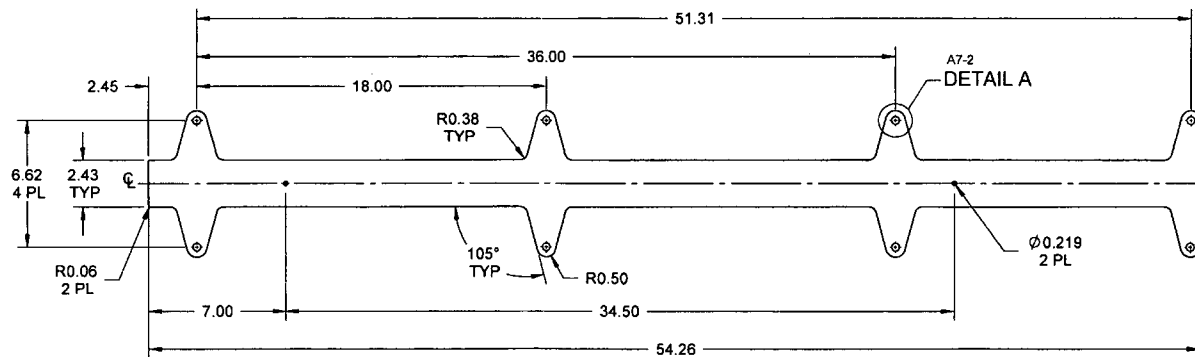
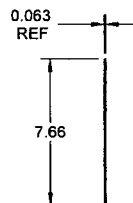
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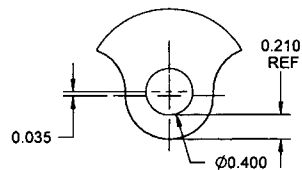
NOTE: Date & initial all entries



D3848-5 GASKET



D3848-7 GASKET



DETAIL B: SLOT DETAIL C1-3
TYP

51842

RELEASED
7/17/17

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MFG. APPR.		D3848	SHEET 3 OF 3
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